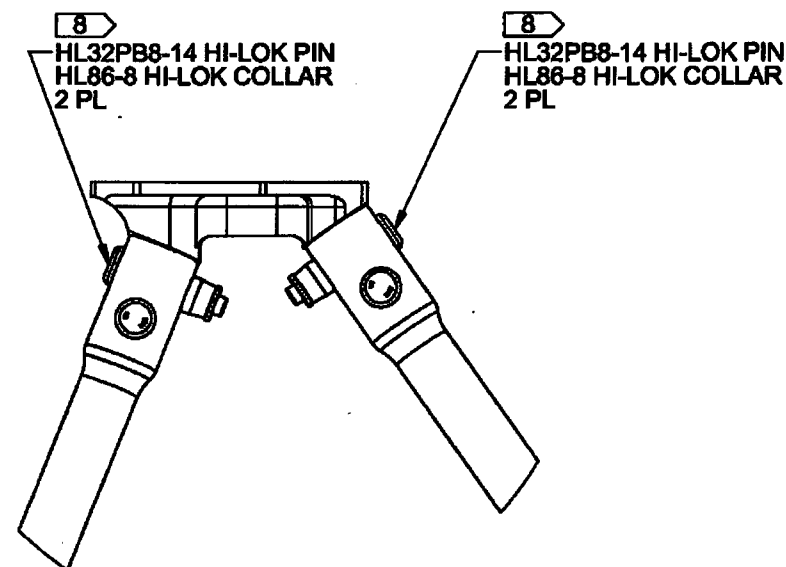
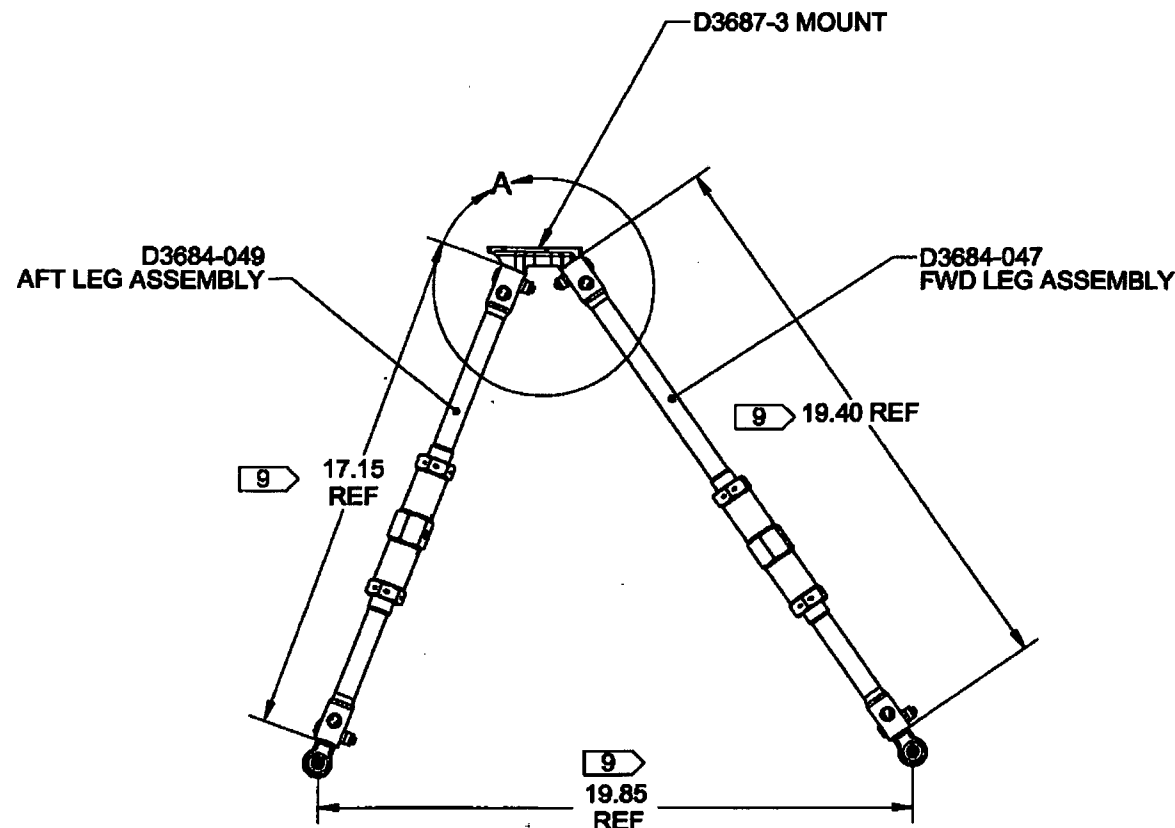


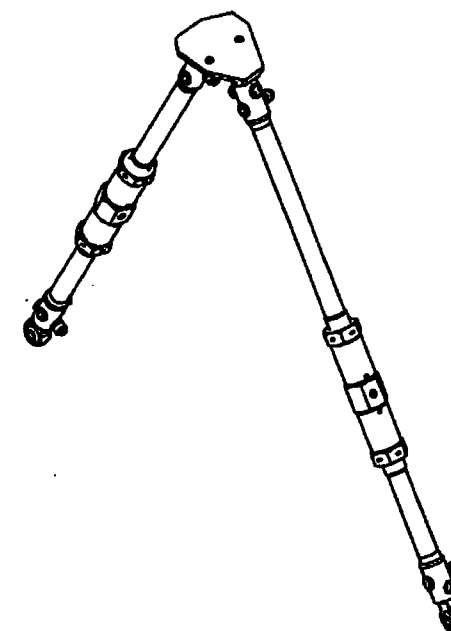
ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D3685-041	BIPOD MOUNT ASSEMBLY
1	1	D3687-3	MOUNT
2	1	D3684-047	FWD LEG ASSEMBLY
3	1	D3684-049	AFT LEG ASSEMBLY
4	4	HL32PB8-14	HI-LOK PIN
5	4	HL86-8	HI-LOK COLLAR



**DETAIL A**  
SCALE 3X



**D3685-041 BIPOD MOUNT ASSEMBLY**



**RELEASED**  
2013-12-01

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 PER DART QSI 044 6.1 ( FINE POINT PAINT MARKER )
- 7) WEIGHT: 6.68 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS . DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER ( 0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047/-049 WITH D3687-3 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES. HI-LOK PIN ORIENTATION AS PER DETAIL 'A'.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

F	ADD DETAIL A, REVERSE THE INSTALLATION ORIENTATION OF HI-LOK PINS TO FACILITATE ASSEMBLY PROCEDURE, CORRECT BOM TABLE	DB	13.11.18
E	REMOVE AN3C-12A BOLT, D3682-1 SPACER AND MS21043-3 NUT, REPLACE WITH HL32PB8-14 HI-LOK PIN, HL86-8 HI-LOK COLLAR, (ZN C3-1, ZN C5-1); RE-FORMAT NOTES SECTION AS PER QSI 043, CHANGE ASSEMBLY ADHESIVES, NOTE8 (ZN A8-1), CHANGE BOM TABLE TO REFLECT NEW ASSEMBLY STRUCTURE, (ZN D8-1) REF NCR 12-2074	DB	12.12.05
F	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. F
MFG. APPR.	AD	<b>D3685</b>	SHEET 1 OF 1
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	<b>BIPOD MOUNT ASSEMBLY</b>	NTS
DATE	13.11.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	